

NCR-19-7744



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4931-5

Job Sheet 188266



Part No: D4931-5

Job Qty: 16 pcs

Part Name: Engine Fitting (for B3e models)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/6/19

Job Tracking No:

Due Date: 1/18/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A SHEET 3 IPP REV:A NEW ISSUE 13-09-16 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier			
100	Doosan - 1	16 pcs	1/18/19	1/18/19	0.00	13.91	Doosan - 1			
110	QC 2	16 pcs	1/18/19	1/18/19	0.00	0.00	QC 2 - 1			
							QC 2 - 12			
							QC 2 - 14			
							QC 2 - 17			
							QC 2 - 19			
							QC 2 - 2			
							QC 2 - 20			
							QC 2 - 22			
							QC 2 - 23			
							QC 2 - 25			
							QC 2 - 32			
							QC 2 - 33			
							QC 2 - 35			
							QC 2 - 38			
							QC 2 - 39			
							QC 2 - 4			
							QC 2 - 40			
							QC 2 - 44			
							QC 2 - 45			
							QC 2 - 48			
							QC 2 - 49			
							QC 2 - 50			
							QC 2 - 51			
							QC 2 - 52			
							QC 2 - 54			
							QC 2 - 56			
							QC 2 - 57			
							QC 2 - 62			
							QC 2 - 63			



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CANADA
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Container No: S177584



Part: D4931-5

Job No: 188266

Serial No/Batch: S177584

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 05/02/19

DAS
5
9-89

				QC 2 - 8		
112	Conventional Mill - 1 - B4B	16 pcs	1/18/19	0.00	6.61	Conventional Mill - 1 - B4B
						Conventional Mill - 2 - B4B
115	QC 2	16 pcs	1/18/19	0.00	0.00	QC 2 - 1
						QC 2 - 12
						QC 2 - 14
						QC 2 - 17
						QC 2 - 19
						QC 2 - 2
						QC 2 - 20
						QC 2 - 22
						QC 2 - 23
						QC 2 - 25
						QC 2 - 32
						QC 2 - 33
						QC 2 - 35
						QC 2 - 38
						QC 2 - 39
						QC 2 - 4
						QC 2 - 40
						QC 2 - 44
						QC 2 - 45
						QC 2 - 48
						QC 2 - 49
						QC 2 - 50
						QC 2 - 51
						QC 2 - 52
						QC 2 - 54
						QC 2 - 56
						QC 2 - 57
						QC 2 - 62
						QC 2 - 63
						QC 2 - 8
120	QC 8	16 pcs	1/18/19	0.00	0.00	QC 8 - 12
						QC 8 - 14
						QC 8 - 17
						QC 8 - 20
						QC 8 - 25
						QC 8 - 3
						QC 8 - 32
						QC 8 - 33
						QC 8 - 35
						QC 8 - 38
						QC 8 - 39
						QC 8 - 4
						QC 8 - 44
						QC 8 - 45
						QC 8 - 49
						QC 8 - 58
						QC 8 - 8
						QC 8 - 9
						QC 8 - 68
						QC 8 - 67
						QC 8 - 1 (A)
130	Packaging 3-2 - Stock - B4B	16 pcs	1/18/19	0.00	0.00	Packaging 3 - 1 - B4B
						Packaging 3 - 2 - B4B
						Packaging 3 - 3 - B4B

					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	PC 5127
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
140	QC 21 - SA	16	1/18/19	0.00 0.00	QC 21 - SA - 21	DAS MAY 15 2019
		pcs			QC 21 - SA - 70	21
						9-89
Part Op 100 - (Doosan Lathe)Machine as per folio FB210 Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB) 112 - (Manufacture as per dwg) DRILL HOLES AS PER REQUIRED 115 - QC2- Inspect parts off machine FAI/FAIB) 120 - QC8- Inspect parts - second check) 130 - Identify as per dwg & Stock Location:_____)) 140 - (QC21- Final Inspection - Work Order Release)						
Job BOM						
Part / Item	Component Name	Quantity	Operation	Container		
M303R2.000	303 Round Bar 2"	2.4000 ft (15 ea)	100-Doosan - 1	5160566	1318	
Job Allocations						
Operation	Component Part	Required	Inventory	Allocated		
100-Doosan - 1	M303R2.000	2	37	0		
Part Specifications						
Specifications could not be found.						

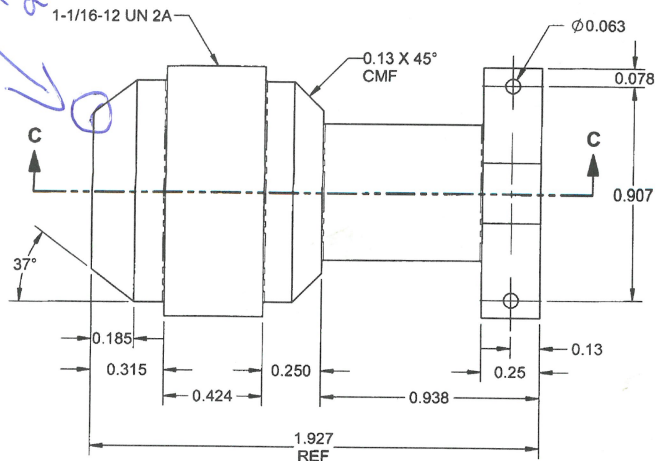
DART AEROSPACE LTD		Work Order:	
Description: EAPS P2 Engine Fitting		Part Number:	D4931-5
Inspection Dwg: D4931	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

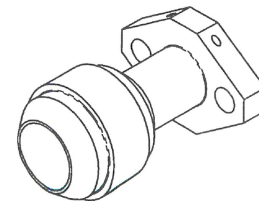
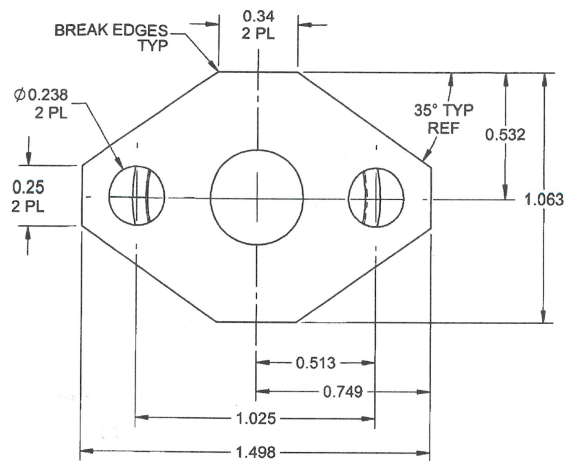
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1-1/16-12 UN 2A	N/A	N/A			Nut Ref and wire ports	
37°	+/-0.5°	37°				
0.185	+/-0.010	.180				
0.315	+/-0.010	.315				
0.424	+/-0.010	.430				
0.250	+/-0.010	.254				
0.938	+/-0.010	.948				
1.927 Ref	+/-0.010	1.930				
0.25	+/-0.030	.256				
0.13	+/-0.030	.125				
0.907	+/-0.010	.901				
0.078	+/-0.010	.07				
Ø0.063	+0.004/-0.001	.0625				
0.13 x 45°	+/-0.030 x +/-0.5°	.125				
0.34	+/-0.030	.350				
0.25	+/-0.030	.260				
Ø0.238	+0.005/-0.001	0.238	✓		Vernier JVO5	
35°	+/-0.5°	35				
0.532	+/-0.010	.529				
1.063	+/-0.010	1.062				
0.513	+/-0.010	0.513	✓		Vernier JVO5	
0.749	+/-0.010	.752				
1.025	+/-0.010	1.025	✓		Vernier JVO5	

Measured by: JMS/14 DC	Audited by: D.F.	Preliminary Approval:
Date: 19/05/02	Date: 19-05-14	Date:
Rev	Date	Change
A	14.06.24	New Issue
Revised by: KJ		Approved:

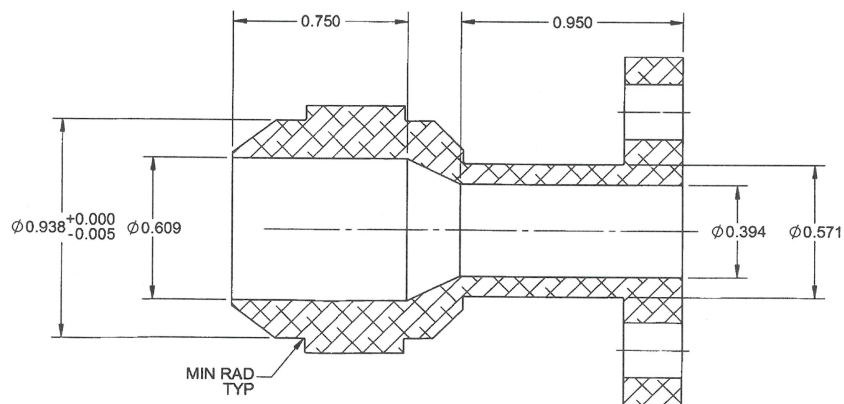
Actual Part Had a Rad



D4931-5 EAPS P2 ENGINE FITTING
(FOR B3 MODELS WITH ARRIEL 2D ENGINES)



1.0551 +/- .0058
DOW 1.0967 +/- .0023



NOTES:

- 1) MATERIAL: AISI 303 STAINLESS STEEL ROUND BAR
PER ASTM A582
REF DART SPEC M303R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.22 lbs

SECTION C-C

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	97	DRAWING NO. D4931	REV. A
MFG. APPR.	97	SHEET 3 OF 3	
APPROVED	97	TITLE	SCALE
DE APPR.	97	EAPS P2 ENGINE FITTING	
DATE	13.09.20	NTS	

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RELEASED
2014-01-08
MD

DQA:

Date:

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed:

Date:

Work Order update only ☐

Work Order: <u>D4931-S/188266</u>		DISPOSITION		AGAINST DEPARTMENT/PROCESS					
Part No. <u>D4931-S</u>		Rework ☐		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
NCR No. <u>19-7744</u>		Scrap ☐		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
		Use-as-is ☒		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
		Suspected Unapproved ☐		Large Fab ☐	Composite ☐	Supplier ☐			
Date: <u>19/5/14</u>		Step #: <u>100</u>		QTY Effective: <u>Qty(1)</u>			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition			<u>WSP 12</u> <u>19/5/14</u>		
Fitting end has $\approx$ R0.020 fillet fillet.				Acceptable. No effect on fit with flex hose.			Completed By <u>19/5/14</u>		
							Lead hand / Supervisor Approval Verification <u>19-05-14</u>		
							QC / QA Coordinator Approval <u>68</u> <u>9-89</u> MAY 14 2019		
Root Cause				FAULT CATEGORY					
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☒	Operator ☒	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☒				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							